

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012498**Date Inspected:** 09-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12AW, weld No.SEG-3004A-014. The welder is identified as #047864. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG Segment 12AW, weld No.SEG-3004A-006. The welder is identified as #045246. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

FCAW in the 1G position for the OBG Segment 12BW performing UT weld repair, weld No.SEG3005*-008. The welder is identified as #201215. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-345-FCAW-1G(1F)-REPAIR.

FCAW in the 1G position for the OBG Segment 12CW performing UT weld repair, weld No.SEG3006*-004. The welder is identified as #201215. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by

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QC appear to comply with WPS-345-FCAW-1G(1F)-REPAIR.

FCAW in the 2G position for the OBG Segment 12AW, weld No.CA3006-003. The welder is identified as #202122. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Traveler Rail, weld No.11TR3-022. The welder is identified as #214945. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-REPAIR. The weld repair report is B-CWR1086.

Ultrasonic Testing (UT) at Bay #14

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG X-37 plate.

The Weld Designations are as follows

CA056-053,054
CA059-045,046
CA061-069,070
CA074-073,074
CA077-021,022
SEG055D-047,052
SEG059E-054,059

Ultrasonic Testing (UT) at Bay #19

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Suspender Bracket.

The Weld Designations are as follows

SB-008-038-049,061,025,037,005
SB-008-038-007,004,018,001,008

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera, Subhasis

Quality Assurance Inspector

Reviewed By: Patterson, Rodney

QA Reviewer